

Work Order ID 55736

January 29, 2010 8:26:45 AM

Page 1

Item ID: D2344

Accept

Setup Start

Revision ID:

Stop

Item Name: Litter Deck Plate, 350

Start Date: 1/28/10 Start Qty: 6.00

Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10/29

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2344	Rev F								
100	FLOW WATER JET	0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet									
2024.063	F F								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

B 10-2-3

7

B 10-2-3

Sidulos

x6

Pro →

W/O: 55736		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/02/06	120	Took @ 1 For QC inspection template	S	10/02/06	1		S 10/02/06

Part No: D2344 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55736

January 29, 2010 8:26:46 AM

Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Deburr sharp edges □2-Countersink holes per Dwg D2344

Signature 2/8/08 (6)

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

⇒ 2/10/09

(x6)

150

0.00



HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

Hand Finishing

⇒ 2/10/09

(x6)

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Work Order ID 55736

January 29, 2010 8:26:46 AM



Page 3

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Start Date: 1/28/10 Start Qty: 6.00



Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 MIDS642 Memo START TIME: 11:00AM 11:30AM FINISH TIME: _____ □OVEN TEMPERATURE: 320°F	0.00 0.00		⇒ 10-02-09		(46)	Φ		
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		10-02-9		⑥	Φ		
180 Packaging Packaging	Identify as per dwg & Stock Location: 227 Memo	0.00 0.00							Per 11 ⑥

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January 29, 2010 8:26:46 AM

Page 4

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Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/11 *[Signature]*
-MF
10-2-11

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NOTE: Date & initial all entries

Picklist Print

January 29, 2010 8:26:53 AM

Page 1

Work Order ID: 55736



Parent Item: D2344

Parent Item Name: Litter Deck Plate, 350

Start Date: 1/28/10

Required Date: 2/08/10

Comments: IPP Rev:D 100.06.26 Removed P/O for powder coat EC
IPP Rev:E 07-07-04 Asper Rev F JLM

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	22.3696	4.7053	5.5		



2024-T3 .063 sheet



10-2-3

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

22.36962419

102942

1.5

105916

1.09

109463

0.00947368

110980

5.4854

111787

12.2847505

19059

2

113866

113866

7

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35736
Description: Litter Deck Plate Kit (350)		Part Number:	D2344
Inspection Dwg: D2344 Rev: F		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.223	+/-0.010	6.227	X			
5.598	+/-0.010	5.602	X			
4.869	+/-0.010	4.876	X			
3.889	+/-0.010	3.891	X			
3.096	+/-0.010	3.093	X			
2.891	+/-0.010	2.893	X			
16.973	+/-0.010	16.983	X			
0.450	+/-0.010	.447	X			
4.423	+/-0.010	4.426	X			
4.723	+/-0.010	4.724	X			
1.202	+/-0.010	1.198	X			
5.869	+/-0.010	5.868	X			
4.654	+/-0.010	4.653	X			
Ø0.656	+0.005/-0.000	.658	X			
1.888	+/-0.010	1.884	X			
2.285	+/-0.010	2.287	X			
2.683	+/-0.010	2.681	X			
Ø0.171	+0.005/-0.000	.171	X			
3.491	+/-0.010	3.497	X			
Ø0.191	+0.005/-0.000	.194	X			
3.123	+/-0.010	3.127	X			
1.975	+/-0.010	1.977	X			
Ø0.128	+0.005/-0.001	.130	X			

Measured by:	IB	Audited by:	S	Prototype Approval:	N/A
Date:	10-2-3	Date:	10/02/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	07.09.06	Dimensions updated per Dwg. Rev. F	KJ/JLM	JE

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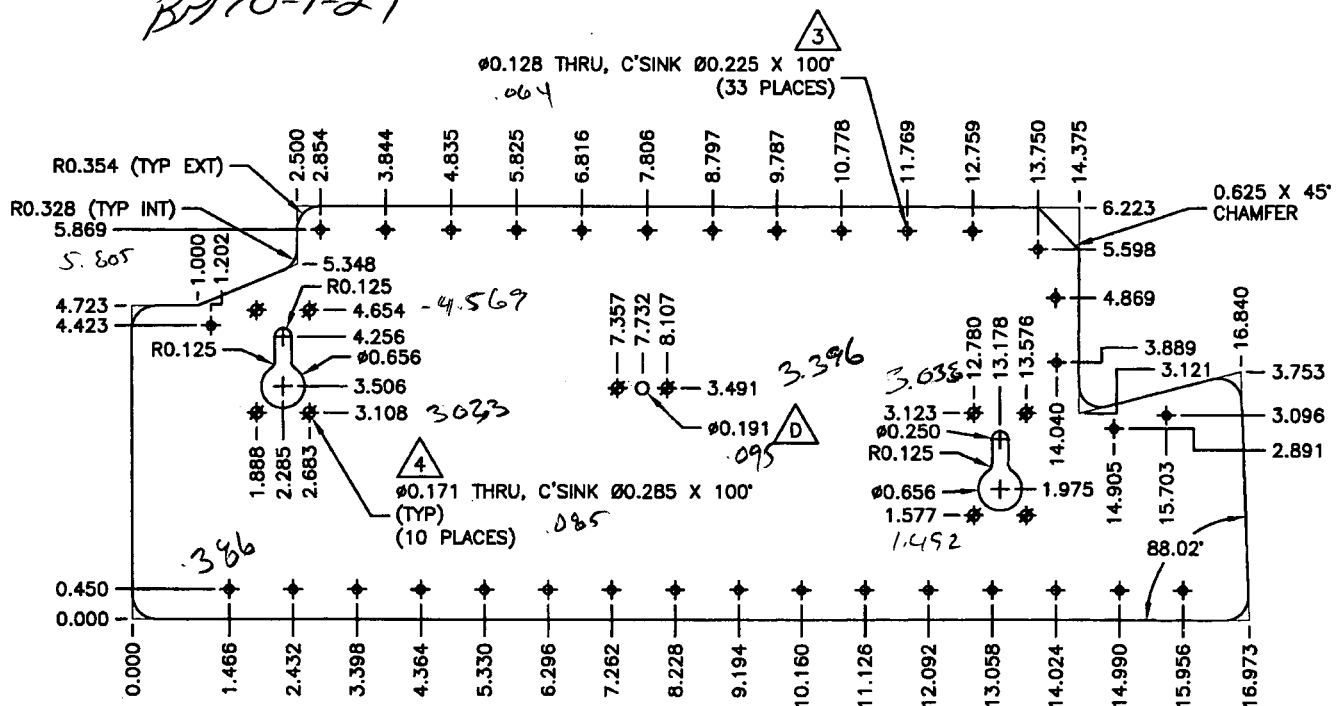
NOTE: Date & initial all entries

DART

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 55736
BA10-1-29

DESIGN KE	DRAWN BY <i>JC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>H</i>	DRAWING NO. D2344	REV. F SHEET 1 OF 1
DATE 07.06.07		TITLE LITTER DECK PLATE, 350	SCALE 1:3
A	95.01.14	NEW ISSUE	
B	95.02.09	MOVED KEY HOLES	
D	95.03.06	0.191 WAS 0.197	
E	98.06.19	0.063-0.071 THICK WAS 0.071 (TSR A371)	
F	07.06.07	C'SINK Ø0.285 WAS Ø0.308	

**D2344 LITTER DECK PLATE, 350**

- E** 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063-0.071 THICK PER QQ-A-250/4 (REF. DART SPEC. M2024T3S)
- F** 2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 3) COUNTERSINK HOLES MARKED \star TO Ø0.225 X 100"
- 4) COUNTERSINK HOLES MARKED \star TO Ø0.285 X 100"
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 8) IDENTIFY WITH DART P/N "D2344" USING WHITE PAINT MARKER

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Dart Aerospace Ltd

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